

Ship July 15

Page 1

Work Order ID 60167

June 28, 2010 11:52:15 AM

Item ID: D4135-1

Accept



Setup Start



Stop



Revision ID:

Item Name: Wearpad

Start Date: 6/29/10 Start Qty: 12.00



Required Date: 7/15/10 Req'd Qty: 12.00



Reference:

Approvals: Process Plan:



Date: 10/6/29 Tooling:



Date: SPC (Y/N):

Cust Item ID:

Customer:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4135

A

0.00

10/6/29

100



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

304 .063

1-Cut as per Dwg D4135
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary

SB 10/6/30

14

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

10/6/29

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

SB 10/6/30

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept



Setup

Start



Stop



QC:

Date:

Tooling:

Date:

Run

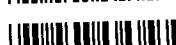
Date:

SPC (Y/N):

Date:

Start

Stop

Reject
NumberInsp.
StampSequence ID/
Work Center ID

130



Brake NC

Brake NC

Operation
DescriptionForm as per dwg
NC BRAKESet Up/
Run Hours

0.00

Tool ID
Tool #
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

POSITIVE RECALL

EFFECTIVE 10.06.29 AUTH PRELEASED GP DATE 10.04.16★ CHECK
FIT OF (1) BENT
PART, SEE CP

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: 21 0.00

Large Fab

0.00

Memo

Weld hard surface using DT _____ as per QSI 004 and Dwg D4135

M 114705

JL 10.07.14

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Start Date: 6/29/10 Start Qty: 12.00



Required Date: 7/15/10 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S. olooyis

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M1112588

0.00

Memo

START TIME: 1:00pm
 OVEN TEMPERATURE: 320°F
 FINISH TIME: 1:30pm

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 60167

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Item Name: Wearpad

Start Date: 6/29/10 Start Qty: 12.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

B 10-07-15 P

200



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

C 10/7/16 19

10-07-16

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF
10-7-16

Sequence ID/ Work Center ID	Operation Description	Memo	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish		0.00							
200	Identify as per dwg & Stock Location:		0.00							
210	QC21- Final Inspection - Work Order Release		0.00							

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

June 28, 2010 11:52:12 AM

Page 1 / 1

Work Order ID: 60167



Parent Item: D4135-1



Parent Item Name: Wearpad

Start Date: 6/29/10

Required Date: 7/15/10

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.25 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty
M304S16GA		Purchased	No			100	sf	77.3439	0.01653	0.2088

304/316 Sheet .063



Location	Loc Qty	Loc Code
MAT	77.34389474	
111323	0	
114799	77.3438947	114799

1B10 - 6 - 89

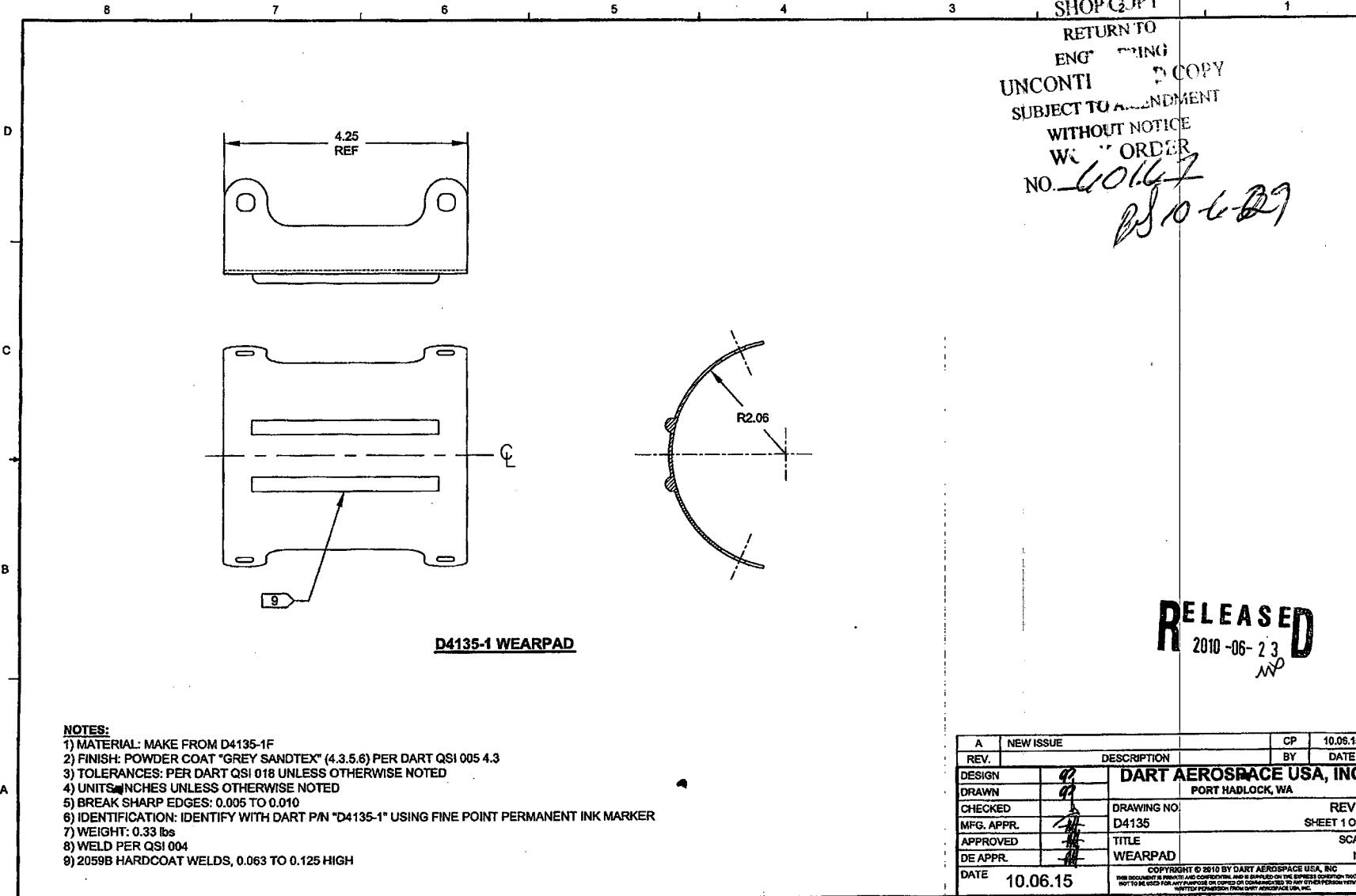
W/O:		WORK ORDER CHANGES						
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A	NEW ISSUE	CP	10.05.15
REV.	DESCRIPTION	BY	DATE
DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4135	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPAD	NTS
DATE	10.06.15	COPRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SHIPPED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE THAN THAT FOR WHICH IT WAS SHIPPED. NO PERSON MAY GET WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

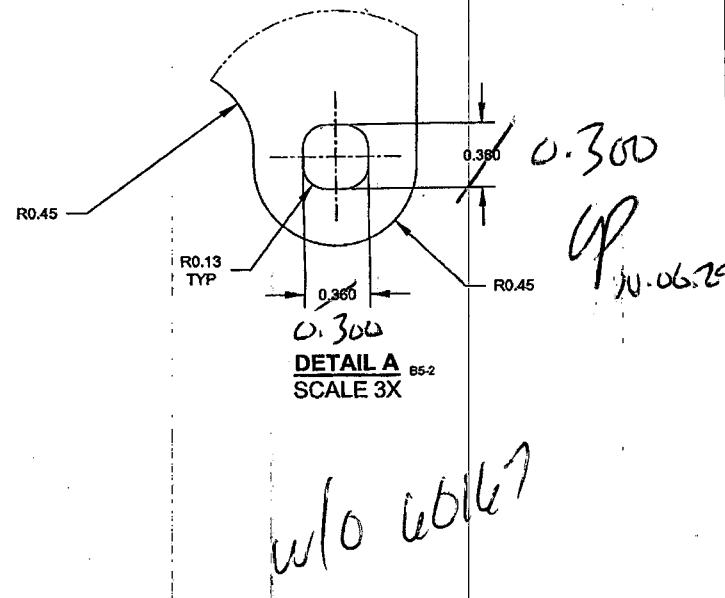
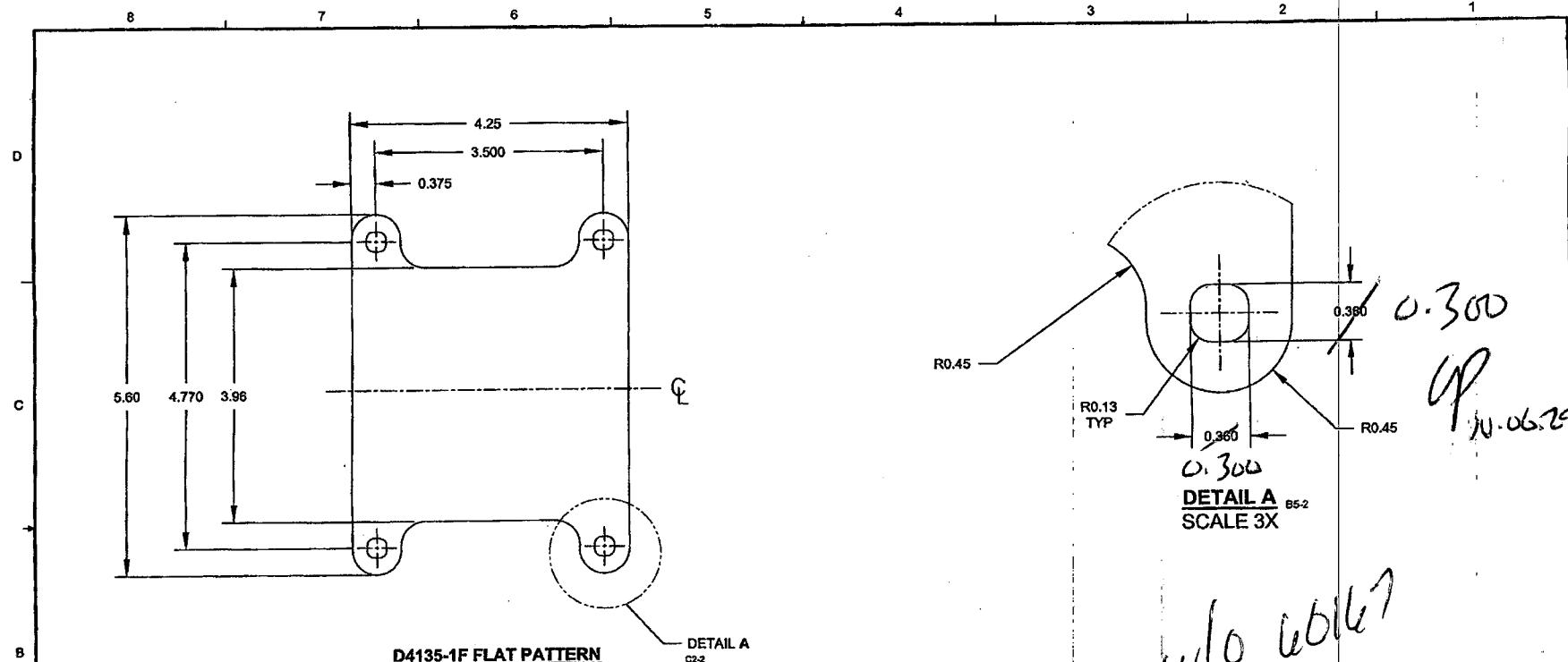
3 2 1

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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524 OR ASTM A240, 16 GAUGE (0.063 THICK)
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	90	DART AEROSPACE USA, INC	
DRAWN	90	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4135	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPAD	NTS
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RELEASED
2010-06-23
MM

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DART AEROSPACE LTD	Work Order:	60167
Description: WEAR PAD	Part Number:	DL4135-1
Inspection Dwg: D4135-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	18
Date:	10-6-39

Audited by:	S
Date:	10/26/30

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	